SPLIT

Work Order ID 56747 – 2

March 8, 2010 9:03:03 AM

7

Item ID: D2571
Revision ID:
Item Name: Saddle, Fwd Out 205

Accept

Setup Start
Stop

Start Date: 10/03/2010 **Start Qty:** 8.00
Required Date: 23/03/2010 **Req'd Qty:** 8.00
Reference: 10.03.08

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2571	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00				7	1		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program Batch No. 56747 Double check by: ☐1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ☐2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐3-Machine Step No 3 per Folio FA051 and inspect					MMF 10/03/10			
110	CONVENTIONAL MILLING MACHINE	0.00				7	1		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572					DJP 10/03/11	MMF 10/03/10		
120	QC2- Inspect parts off machine FAI/FAIB	0.00				7	1		
QC	**Memo**	0.00							
Quality Control						MMF 10/03/10 DJP 10/03/11			

Pto →
~~Last Page~~

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: _____ Fault Category: Machined Parts NCR: (Yes) No DQA: [signature] Date: 10.03.15

Resolution: Scrap Disposition: scrap QA: N/C Closed: [signature] Date: 10/03/30

NCR: 56747-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
10/03/13	# 100	1 part lifted in 4 operation R.C. Process / Tool dug into the parts because of vibration	[signature]	Scrap & replace Qty x1 M 46417 - Additional clamps placed on the machine for extra support.	[signature] 10/03/13	[signature] 10/03/24	[signature]	[signature] 10/03/15

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 56747

March 8, 2010 9:03:03 AM

Item ID: D2571 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010 **Start Qty:** 8.00 **Cust Item ID:**

Required Date: 23/03/2010 **Req'd Qty:** 8.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	S.P 10/03/16			7	1		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	M 10/03/16			X7	Ø		
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	M11317 0								
	Memo	0.00	=> ld 10/03/6			X7	Ø		
Powder Coating	START TIME: 2:20 pm OVEN TEMPERATURE: 320°C FINISH TIME: 2:50 pm								

Work Order ID 56747

March 8, 2010 9:03:03 AM

Item ID: D2571 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010 **Start Qty:** 8.00 **Cust Item ID:**

Required Date: 23/03/2010 **Req'd Qty:** 8.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00	BK 10-3-16			7	0		
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 433	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Cie 10/3/22 0

10/03/24

MF
10-3-22

Picklist Print

March 8, 2010 9:03:02 AM

Work Order ID: 56747

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010 **Required Date:** 23/03/2010

Comments: IPP: I□02.10.02□Re-format; Change to Dwg Rev. D & incorporated D2572□KJ□

Start Qty: 8.00 **Required Qty:** 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	74.0000	8.0000			
Saddle Billet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	74	
41960	1	
46412	73	MNE 10/03/09

8 +1

DART AEROSPACE LTD	Work Order:	56747
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.496	3.495	3.496	3.494		
D	1.745	1.755		1.746	1.747	1.747	1.747		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.500	.510	.499	.500		
G	0.257	0.262		.258	0.259	0.259	0.259		
H	0.375	0.380		.377	0.377	0.377	0.377		
I	0.490	0.510		.499	0.498	.496	.498		
J	1.174	1.184		1.174	1.179	1.179	1.179		
K	0.558	0.578		.567	0.560	.560	.560		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.492	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.870	3.874	3.874	3.874		
P	0.115	0.135		.126	0.126	0.127	0.126		
Q	0.115	0.135		.127	0.135	.135	.135		
R	0.240	0.260		.247	0.248	0.250	0.249		
S	0.115	0.135		.128	0.130	.127	.126		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	0.235	.237	.235		
W	0.115	0.135		.125	0.120	.125	.125		
X	0.308	0.313		0.309	.310	.309	.310		
Y	0.760	0.765		0.761	.760	.761	.760		
Z	0.352	0.372		.367	.367	.365	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		.626	.627	.627	.627		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	0.250	.250	.250		
AE	1.375	1.395		1.387	1.390	1.392	1.392		
AF	0.115	0.135		.135	0.139	.135	.135		
AG	0.240	0.280		.250	0.255	0.255	0.255		
AH	0.240	0.260		.250	0.244	.243	.245		
AI	2.000	2.020		2.002	2.005	2.005	2.005		
AJ	0.023	0.043		0.033	.035	.033	.033		
Accept/Reject									

Measured by:	DJP / MV	Audited by	L.P
Date:	10/03/11 / 10/03/15	Date:	10/03/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	56747
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

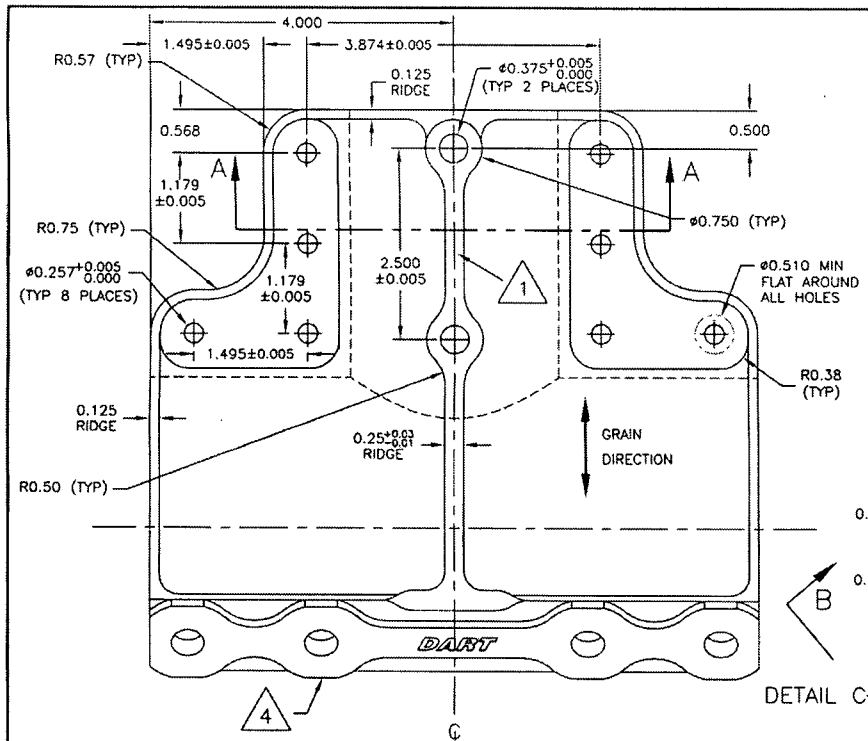
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

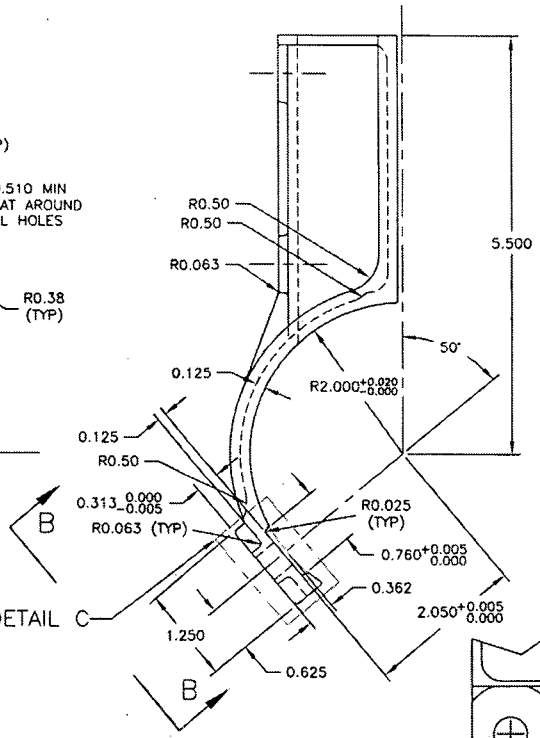
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	4	By	Date
A	0.438	0.443		.440	.440	.440			
B	1.745	1.755		1.747	1.747	1.747			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.747	1.747	1.747			
E	7.990	8.010		8.003	8.004	8.003			
F	0.490	0.510		.500	.500	.500			
G	0.257	0.262		.260	.260	.260			
H	0.375	0.380		.377	.377	.377			
I	0.490	0.510		.496	.497	.498			
J	1.174	1.184		1.179	1.179	1.180			
K	0.558	0.578		.560	.560	.560			
L	1.174	1.184		1.179	1.179	1.180			
M	1.490	1.500		1.498	1.498	1.498			
N	2.495	2.505		2.498	2.500	2.500			
O	3.869	3.879		3.876	3.875	3.874			
P	0.115	0.135		.127	.125	.125			
Q	0.115	0.135		.130	.133	.135			
R	0.240	0.260		.250	.248	.248			
S	0.115	0.135		.124	.124	.125			
T	0.178	0.198		.188	.188	.188			
U	2.940	2.980		2.960	2.960	2.957			
V	0.230	0.250		.237	.240	.234			
W	0.115	0.135		.127	.126	.125			
X	0.308	0.313		.310	.310	.310			
Y	0.760	0.765		.761	.761	.761			
Z	0.352	0.372		.365	.366	.365			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.622	.623	.628			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.250	.250	.250			
AE	1.375	1.395		1.390	1.393	1.394			
AF	0.115	0.135		.135	.135	.135			
AG	0.240	0.280		.275	.273	.248			
AH	0.240	0.260		.251	.253	.246			
AI	2.000	2.020		2.006	2.007	2.006			
AJ	0.023	0.043		.033	.033	.033			
Accept/Reject									

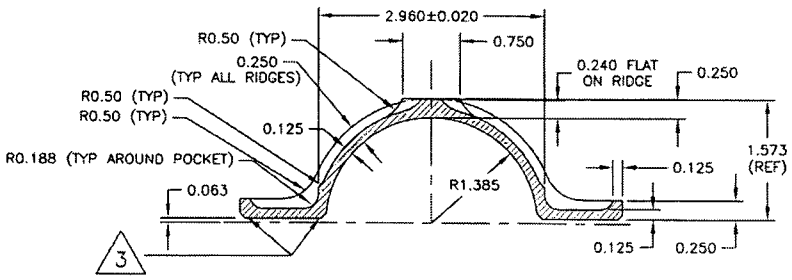
Measured by:	MWD
Date:	10/03/15

Audited by	S.B
Date:	10/03/16

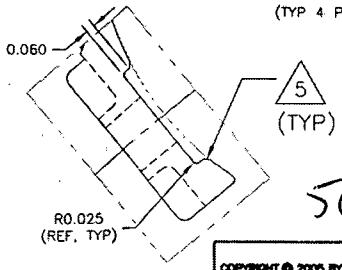
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	







SECTION A–A



DETAIL C
SCALE 4:3

RELEASED
05.12 ok

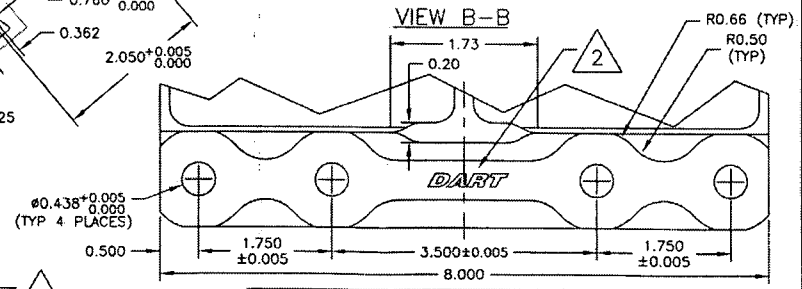
NOTES

MATERIAL: 7075–T7351 (QQ–A–250/12) (REF DART SPEC. D6102–001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)

E

VIEW B–B



56747

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN: DS	DRAWN BY: PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED:	APPROVED:	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE: 05.07.13		TITLE: OUTER FWD SADDLE	SCALE 2:3